

ABSTRACT OF THE DISCLOSURE

A process is provided for forming a resistance welding electrode. The process includes the step of providing a billet formed from a high conductivity metal. The billet includes a
5 first portion having a first inner cavity formed therein. The process further includes the steps of inserting a dispersion strengthened copper insert into the first inner cavity of the billet thereby forming an insert-containing billet, and deforming
10 the insert-containing billet so as to mechanically lock the insert in place in the billet. The deformed insert-containing billet comprises the resistance welding electrode.

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